

Date: Tuesday, 24/02/2009 8:26:03 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3319
Job Number	: 46033		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D33191
This Issue	: 24/02/2009 S.O. No. :	Drawing Number	: R09-014
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 03/03/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>ME 09-02-24</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	QC	QUALITY CONTROL
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Comment: QUALITY CONTROL

Qty 1 D3319-3 B43724 is scrap. Aft hole is torn upon installation.
 Scrap and destroy.

*** To be reworked***

2x D3319-1 original B44082

1x D3319-3 original B43724

209-02-24

SS 09/04/24 (X3)

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Strip the following items, and re-powder coat Grey per QSI005 4.3.5.6

= 209-04-23 (1)

2x D3319-1

1x D3319-3

Start time: *2:30*Oven temp: *320°*Finsih time: *3:00*

BR 09-04-23 (1)

3.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/23 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: D3319

Job Number: 46033

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 *original B/N*
Identify the items with this new batch # and return to stock:

W Location: *ST 497*

5.0

QC21

FINAL INSPECTION/W/O RELEASE



W Comment: FINAL INSPECTION/W/O RELEASE
attach copy of this with each original B/N

09/04/30

Job Completion

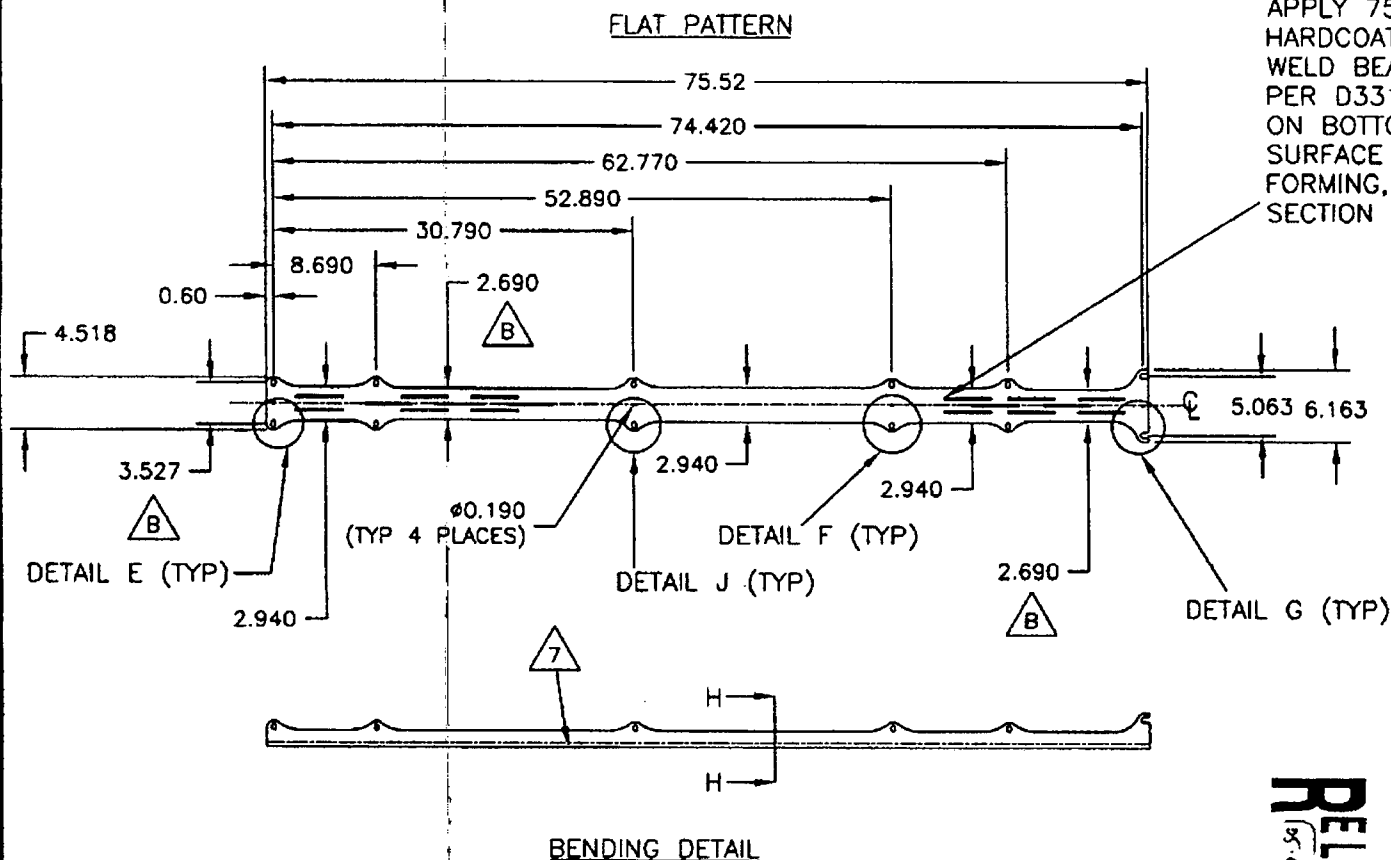


mf
09-04-30

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHKD	APPROVED	DRAWING NO.	REV. B
DATE		D3319	SHEET 2 OF 5
05.06.06		TITLE	SCALE
		WEARPLATE	1:1.5

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

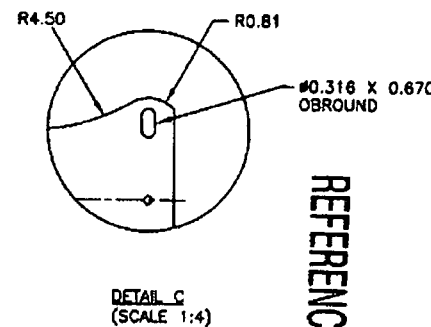
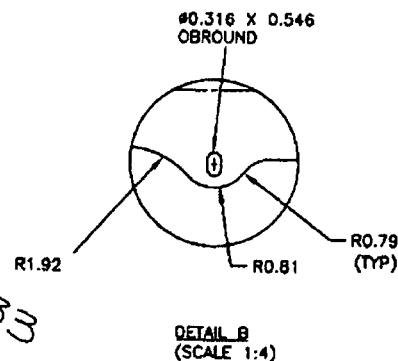
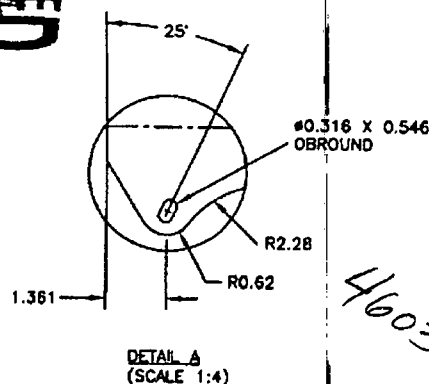
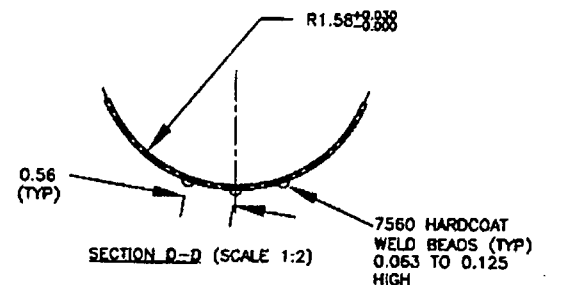
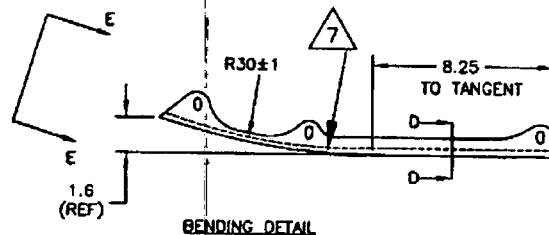
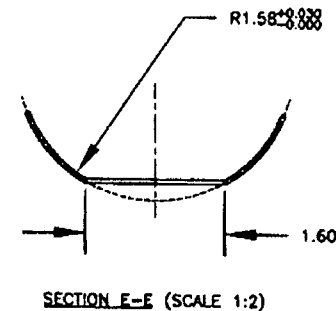
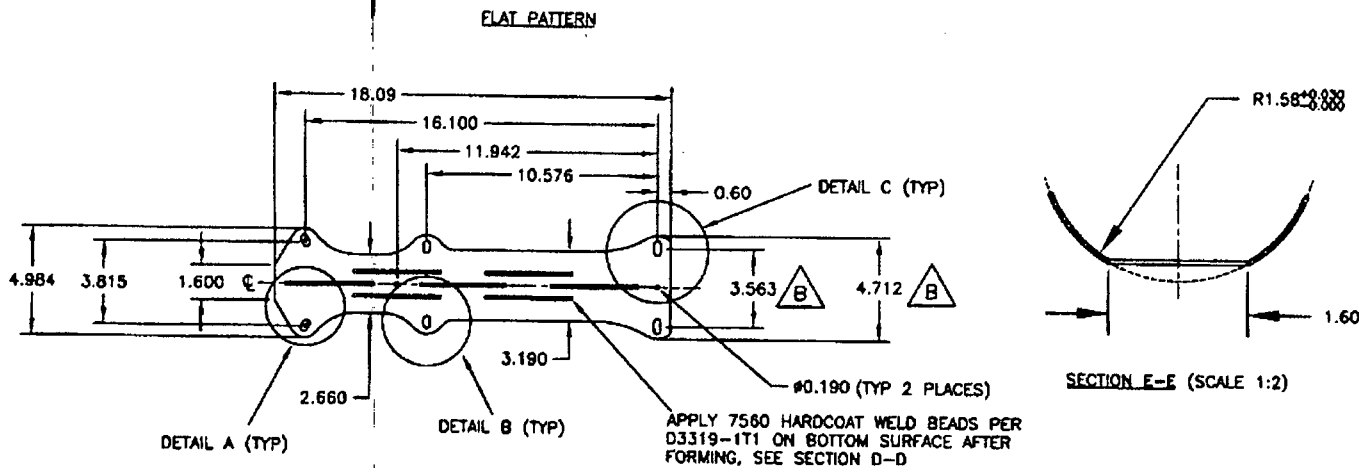


D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASE
REFERENCE ONLY

DART



REFERENCE ONLY

D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	P1	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
A	NEW ISSUE	REV. B
05.06.06		SHEET 1 OF 5
B	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	

RELEASED
(05 of 30)